Date: Thursday, 2/22/2007 3:09:37 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 30858
Estimate Number : 10197
P.O. Number : N/A
This Issue : 2/22/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : LARGE FAB ASSY
Previous Run : 30857
Written By :
Checked & Approved By : 07.02.23
Comment : Est Rev:M 05.09.02 Added D2856-400-720 KJ/JLM

Drawing Name : HELI UTILITY BASKET LH/RH
Part Number : D350607041
Drawing Number : D350-607 REV F P7-9
Project Number : N/A
Drawing Revision : F
Material : N/A
Due Date : 3/28/2007 Qty: 1 Um: Each

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy bluefile & type labels per PPPD350-607-041 CHG006 KS 07.03.05 (1)

Seq. #:	Machine Or Operation:	Description :
2.0	30858A	BASKET BASE ASSEMBLY (350)

Comment: Sub-Component BASKET BASE ASSEMBLY (350)
D2221 B 30858A.

Seq. #:	Machine Or Operation:	Description :
3.0	30858B	350/212/130 BASKET LID

Comment: Sub-Component 350/212/130 BASKET LID
D2512 B 30858B

Seq. #:	Machine Or Operation:	Description :
4.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick: Assemby Kit

Seq. #:	Machine Or Operation:	Description :
5.0	D2022101	Spacer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	D2022-101	Spacer	B30543

7/5/24 5U

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 3:09:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 30858

Part Number: D350607041

Job Number:

Seq. #: **Machine Or Operation:** **Description :**

6.0 D2258200 Weight Placard 200lb

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
1	D2258-200	Label	B31104

7.0 D2332041 Lid Prop Assembly 6.69"

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
1	D2332-041	Prop Ass'y	B31108

8.0 D2530 Handle Weldment

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
1	D2530	Handle Weldment	B30383

9.0 D2535 Spring

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	D2535	Spring	B28363

10.0 D2537 Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	D2537	Bushing	B31107

11.0 D27283 Dart Logo label large

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	D2728-3	Label	B22553

7/5/24 SP

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 3:09:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 30858
Part Number: D350607041

Job Number:

Seq. #:	Machine Or Operation:	Description :
12.0	D2931	Bumper

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	D2931	Bumper	B21139

Seq. #:	Machine Or Operation:	Description :
13.0	AN316A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	AN3-16A	Bolt	M101884

Seq. #:	Machine Or Operation:	Description :
14.0	AN47A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	AN4-7A	Bolt	M16149

Seq. #:	Machine Or Operation:	Description :
15.0	AN422A	Bolt

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
1	AN4-22A	Bolt	M100771

Seq. #:	Machine Or Operation:	Description :
16.0	AN424A	Bolt

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
1	AN4-24A	Bolt	M107931

Seq. #:	Machine Or Operation:	Description :
17.0	AN517A	Bolt

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
4	AN5-17A	Bolt	M102140

7/5/2439

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 3:09:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** HELI UTILITY BASKET LH/RH

Job Number: 30858 **Part Number:** D350607041

Job Number:

Seq. #:	Machine Or Operation:	Description :
18.0	AN960JD8	Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	AN960JD8	Washer	M103585

Seq. #:	Machine Or Operation:	Description :
19.0	AN960JD416	Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	AN960JD416	Washer	M103691

Seq. #:	Machine Or Operation:	Description :
20.0	AN960JD416L	Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	AN960JD416L	Washer	M103962

Seq. #:	Machine Or Operation:	Description :
21.0	AN960JD516	Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
4	AN960JD516	Washer	M103641

Seq. #:	Machine Or Operation:	Description :
22.0	AN9704	Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
4	AN970-4	Washer	M103344

Seq. #:	Machine Or Operation:	Description :
23.0	MS20600AD4W3	Cherry Rivets

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	MS20600AD4W3	Rivet	M101519

3/5/2459

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 3:09:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** HELI UTILITY BASKET LH/RH

Job Number: 30858 **Part Number:** D350607041

Job Number:

Seq. #:	Machine Or Operation:	Description :
24.0	MS21042L3	Nut

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 MS21042L3 Nut (or -3) M103641

Seq. #:	Machine Or Operation:	Description :
25.0	MS21042L4	Nut

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 MS21042L4 Nut (or -4) M103552

Seq. #:	Machine Or Operation:	Description :
26.0	MS21042L5	Nut

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 MS21042L5 Nut (or -5) M102536 3/5/24 SP

Seq. #:	Machine Or Operation:	Description :
27.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D350-607

Seal support gusset seam with white sikaflex-291 Batch: M103497
Expiry date: 10/2007 MF 07-05-25 (1)

Seq. #:	Machine Or Operation:	Description :
28.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP SB 07/05/25 (1)

Seq. #:	Machine Or Operation:	Description :
29.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick: Packing Kit

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 3:09:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 30858

Part Number: D350607041

Job Number:

Seq. #:	Machine Or Operation:	Description :
30.0	D22301	Mounting Lug

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
4	D2230-1	Lug	B30992

Seq. #:	Machine Or Operation:	Description :
31.0	D22303	Mounting Lug

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
4	D2230-3	Clamp	B30545

Seq. #:	Machine Or Operation:	Description :
32.0	D23241	Strut Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
1	*D2324-1	Strut Ass'y	B30139

Seq. #:	Machine Or Operation:	Description :
33.0	D2856400	Abrasion Strip

Comment: Qty.: 0.6000 f(s)/Unit Total : 0.6000 f(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
4	D2856-400-720	Abrasion Strip	B30822

Seq. #:	Machine Or Operation:	Description :
34.0	AN412A	Bolt

Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
5	AN4-12A	Bolt	M103947

Seq. #:	Machine Or Operation:	Description :
35.0	AN413A	Bolt

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
8	AN4-13A	Bolt	M103947

8/5/24 SQ

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes (No) **DQA:** D **Date:** 07/05/25

QA: N/C Closed: _____ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** HELI UTILITY BASKET LH/RH

Job Number: 30858 **Part Number:** D350607041

Job Number:

Seq. #:	Machine Or Operation:	Description :
36.0	AN960JD416	Washer
Comment:	Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 26 AN960JD416 Washer M103691	
37.0	MS21042L4	Nut
Comment:	Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 13 MS21042L4 Nut (or -4) M102857	7/5/24 S4
38.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
	CS 07/05/24 ①	
Comment:	INSPECT 100% KITS FOR COMPLETENESS	07/05/24 ①
39.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment:	PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D350-607-041 Location: NRV G	C 7/5/25 ①
40.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment:	FINAL INSPECTION/W/O RELEASE	07/05/25 ①

Job Completion

07.05.25

Dart Aerospace Ltd

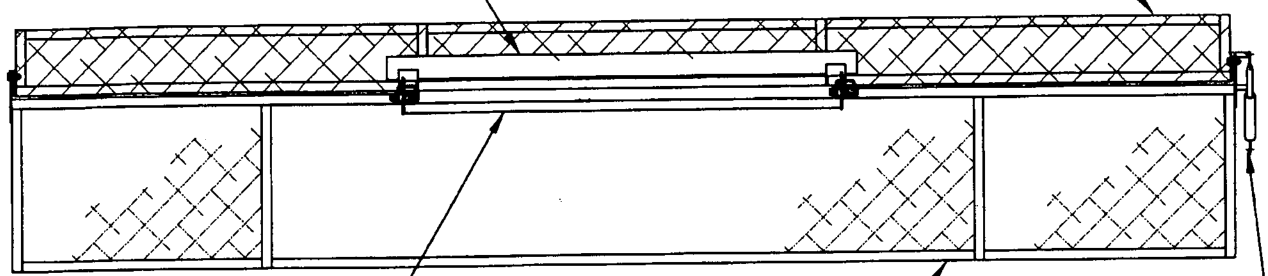
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

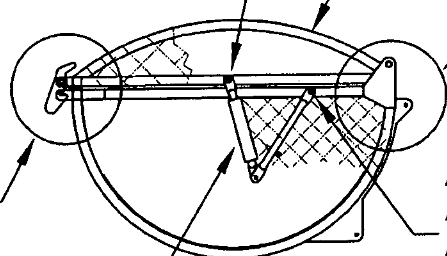
Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

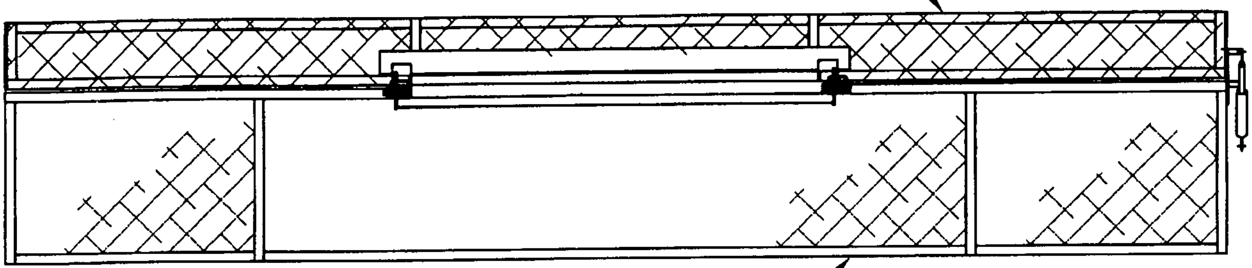
NOTE: Date & initial all entries

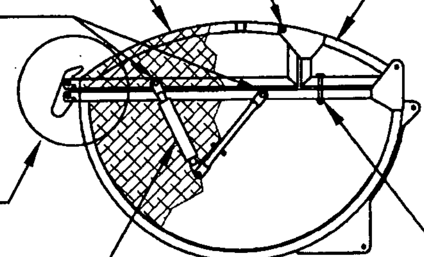




PROP ARM DETAIL
(VIEW C-C)

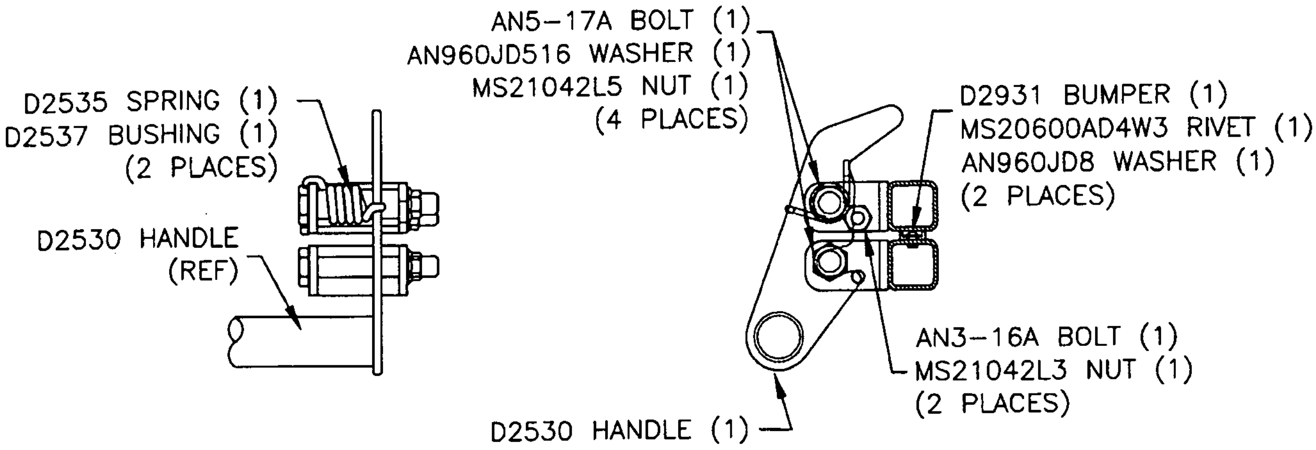
Figure 4 – Basket Replacement Parts
(D350-607-041 Heli-Utility-Basket™)





PROP ARM DETAIL
VIEW C-C

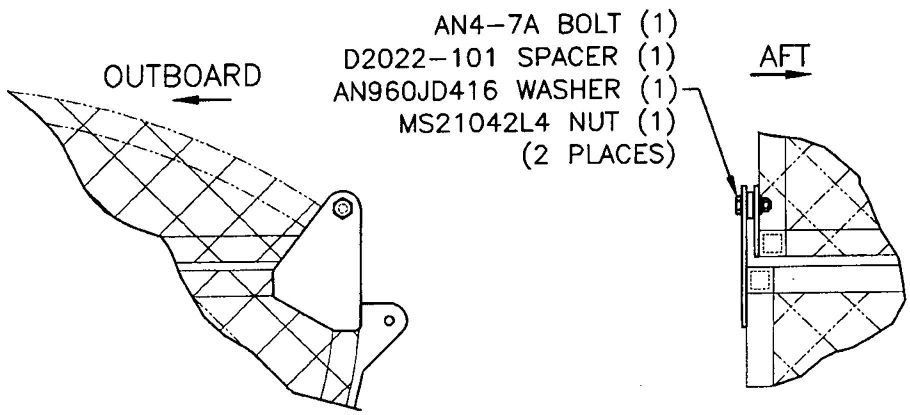
Figure 5– Basket Replacement Parts
(D350-607-043 Heli-Utility-Basket™)



SPRING DETAIL

LATCH DETAIL

DETAIL J:
HANDLE WELDMENT



HINGE DETAIL
END VIEW, LOOKING AFT
OTHER END OPPOSITE

HINGE DETAIL
SIDE VIEW, LOOKING OUTBOARD.
OTHER END OPPOSITE

DETAIL H:
HINGE

Figure 6 – Basket Replacement Parts

Dart Aerospace Ltd.

Date: Thursday, 2/22/2007 3:10:07 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350/212/130 BASKET LID
Job Number	: 30858B		
Estimate Number	: 10193		
P.O. Number	: N/A	Part Number	: D2512
This Issue	: 2/22/2007 S.O. No. : N/A	Drawing Number	: D2512 REV D2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: D2
Previous Run	: 30857B	Material	: N/A
Written By	:	Due Date	: 3/28/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.02.23		
Comment	: Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/RF Est Rev:N 06.04.05 Added level21 EC		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W

Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)
Pick:
3/4"x3/4" 304/316 SS tube .063" wall
Batch: M104307
07.05.24

Seq. #:	Machine Or Operation:	Description :
2.0	D31663	Basket Hoop

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3166-3	Basket Hoop	331118

07.05.24

Seq. #:	Machine Or Operation:	Description :
3.0	D2506	Placard

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2506	Label Plate	330548

07.05.24

Seq. #:	Machine Or Operation:	Description :
4.0	D23271	Spacer Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2327-1	Bushing	328334

07.05.24

 Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 3:10:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 350/212/130 BASKET LID

Job Number: 30858B
Part Number: D2512

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	D22321	Hinge

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2232-1	Hinge plate	B29535

Cpl 07-05-24

Seq. #:	Machine Or Operation:	Description :
6.0	D2581	Mounting Bracket

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2581	Mounting Bracket	B31189

Cpl 07-05-24

Seq. #:	Machine Or Operation:	Description :
7.0	M304EX07516F	Expanded Metal Flat Stai

Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)
Pick:

Qty	Part Number	Description	Batch
18 sf	M304EX0.75-16F	Expanded Metal	M103645

Cpl 07-05-24

Seq. #:	Machine Or Operation:	Description :
8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

Cpl 07-05-24

Seq. #:	Machine Or Operation:	Description :
9.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION

07/05/24

Seq. #:	Machine Or Operation:	Description :
10.0	QC6	DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK

07/05/24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ **PAR #:** ______ **Fault Category:** ________ **NCR:** Yes (No) **DQA:** [signature] **Date:** 07/05/25

QA: N/C Closed: _____ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 3:10:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 350/212/130 BASKET LID

Job Number: 30858B
Part Number: D2512

Job Number:

Seq. #:	Machine Or Operation:	Description :
11.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	MV03141 07 05.24 (1)
12.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4 Batch: M104281	07/05/25 (1)
13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	MF 07-05-25 (1)
14.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: GA	8B 07/05/25 (1)
15.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	07/05/25 (1)

Job Completion

07.05.25

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

CA COPY ISSUED

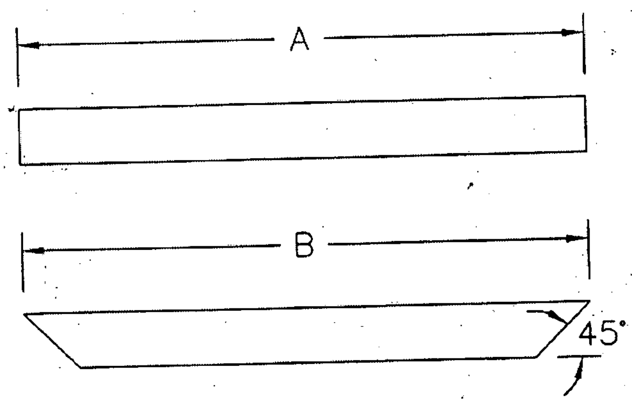
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
BW			
CHECKED	APPROVED	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE NTS

RELEASED 01.04.27

REV	DATE	DESCRIPTION
A	95.11.21	NEW ISSUE
B	96.05.24	ADDED LATCH CHANNEL & LABEL PLATE
C	99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074
D	01.04.19	CHANGE HINGE
D1	03 01. 20	ADD D2012-117 FOR D130-701-041
D2	04.09.20	TACK WELD ANTI-SKID AREA

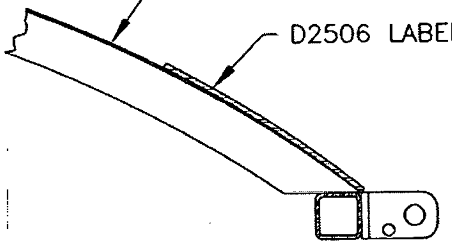
PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	——	25.50	RIB
D2512-3	2	——	95.30	RIB
D2512-5	6	30.84	——	RIB
D2512-7	3	30.63	——	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT

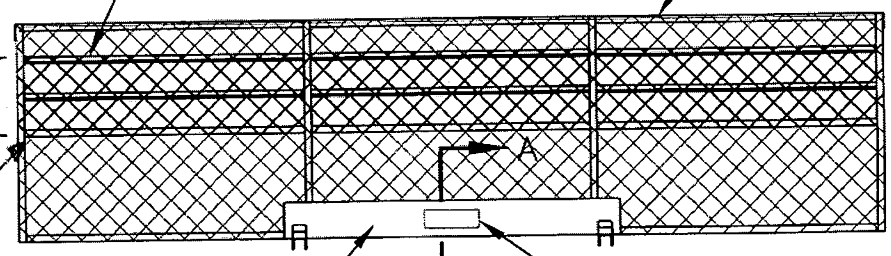


D2512-1/-3/-5/-7
CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

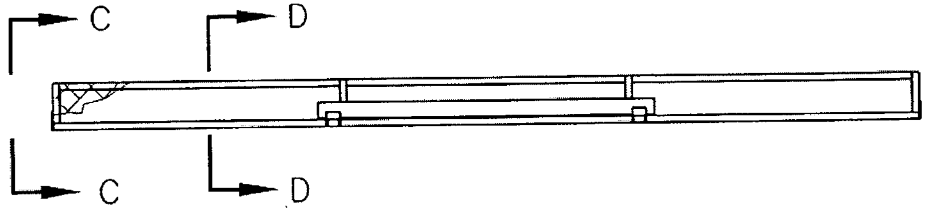
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 30858B



SECTION A–A
(ROTATED 90° CCW)







D2512 BASKET LID ASSEMBLY

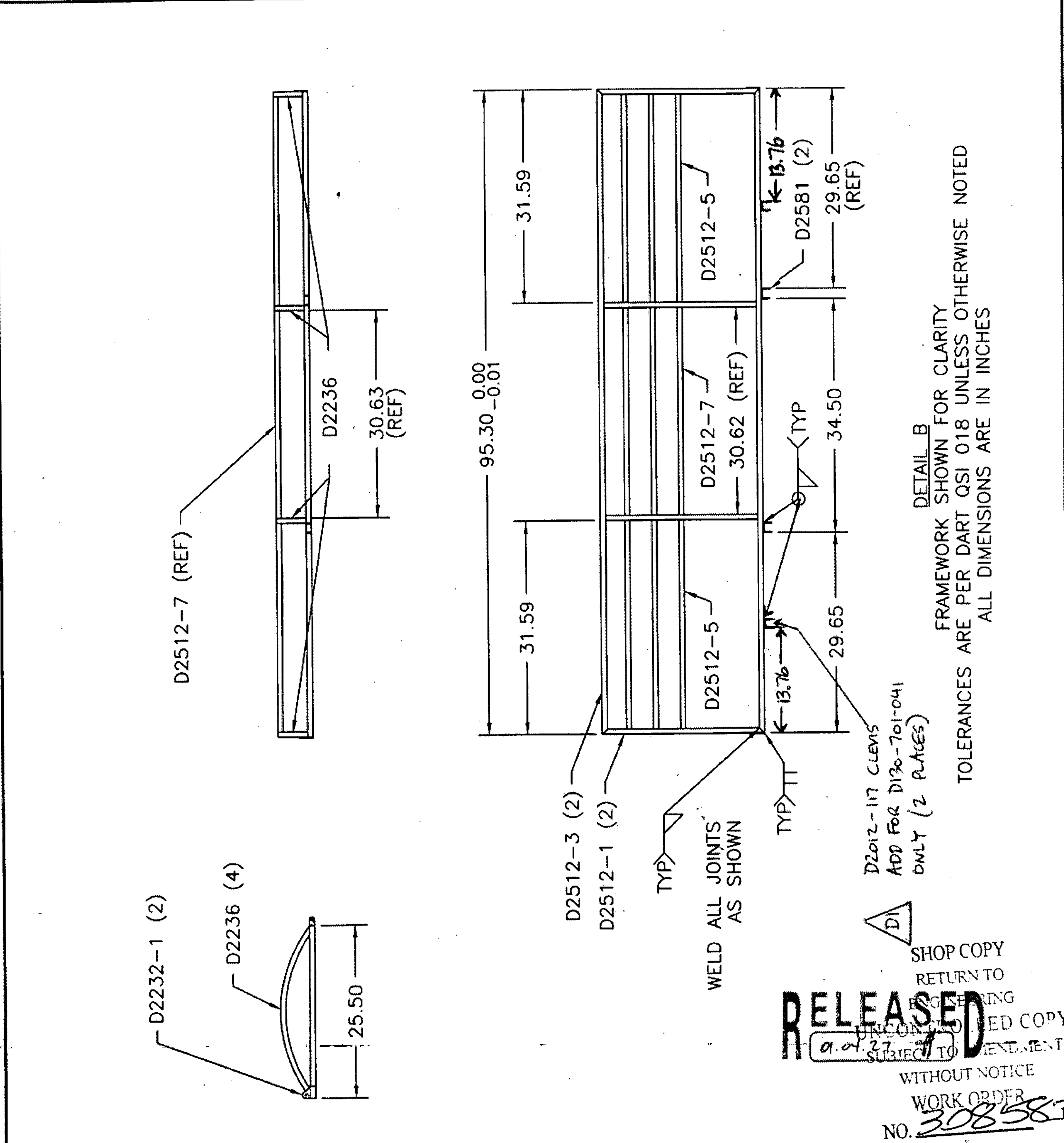
1) MESH MATERIAL: 3/4–16F EXPANDED SS
2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
3) SPRAY PAINT BLACK INSIDE SURFACE
   APPLY BLACK ANTI–SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES

DART

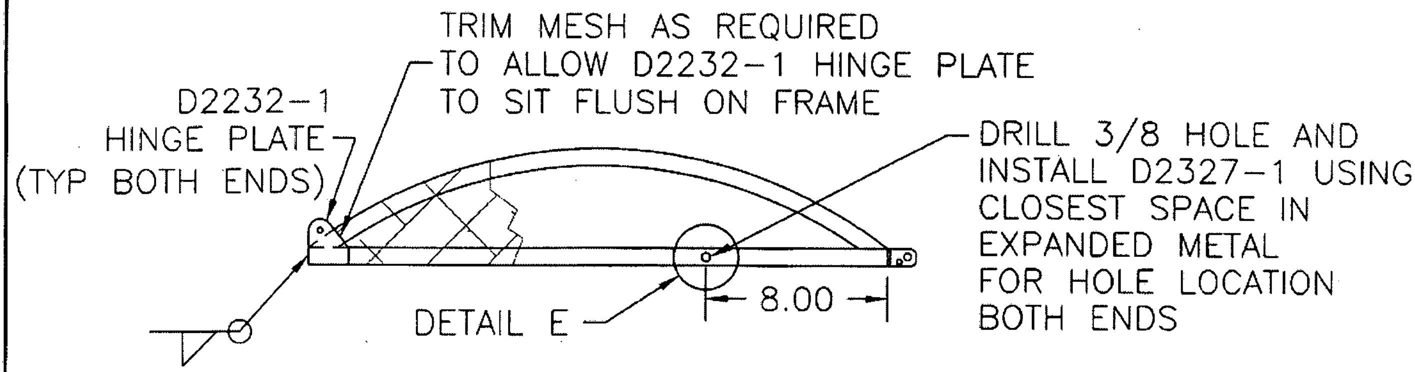
DESIGN	BW	DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO. D2512 — REV. D
DATE	01.04.19			TITLE BASKET LID ASSEMBLY (350/212) — SHEET 2 OF 4 — SCALE 1:20

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
BW	[illegible]		
CHECKED	APPROVED	DRAWING NO. D2512	REV. D SHEET 3 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:20

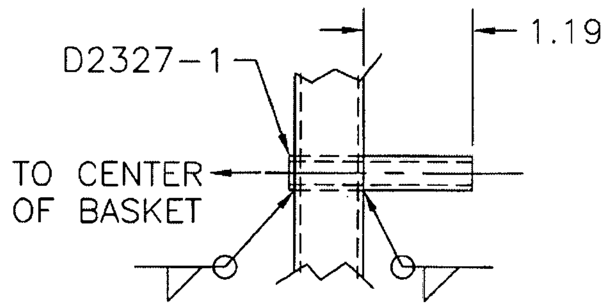
QA COPY ISSUED



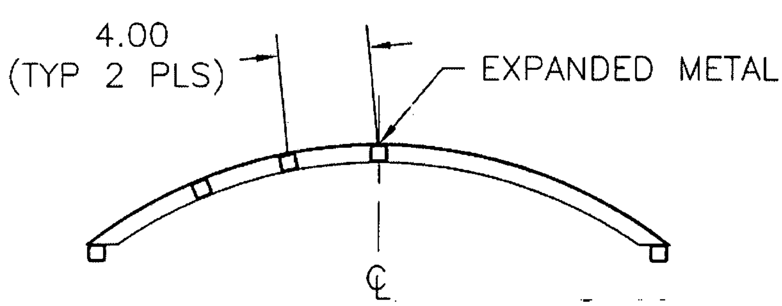
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
BW	CP		
CHECKED	APPROVED	DRAWING NO. D2512	REV. D SHEET 4 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:8



SECTION C-C SIMILIAR BOTH END RIBS



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

Date: Thursday, 2/22/2007 3:09:54 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: BASKET BASE ASSEMBLY (350)
Job Number	: 30858A		
Estimate Number	: 10189		
P.O. Number	: N/A	**Part Number**	: D2221
This Issue	: 2/22/2007 **S.O. No.** : N/A	**Drawing Number**	: D2221/D2235
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LARGE FAB ASSY	**Drawing Revision**	: F/B1
Previous Run	: 30857A	**Material**	: N/A
Written By	:	**Due Date**	: 3/28/2007 **Qty:** 1 **Um:** Each
Checked & Approved By	: 07.02.23		
Comment	: Est Rev: 05.09.02 Added D3442-1 KJ/JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D31661	Basket Hoop

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	D3166-1	RIB	B31271

07·05·24

Seq. #:	Machine Or Operation:	Description :
2.0	D22323	Basket Hinge

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2232-3	Hinge bracket	B30873

07·05·24

Seq. #:	Machine Or Operation:	Description :
3.0	D2325	

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	D2325	Support Gusset	B30546

07·05·24

Seq. #:	Machine Or Operation:	Description :
4.0	D23273	Spacer Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2327-3	Bushing	B31785

07·05·24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: _________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B						
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 3:09:55 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | **Drawing Name:** BASKET BASE ASSEMBLY (350)

Job Number: 30858A | **Part Number:** D2221

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	D2581	Mounting Bracket

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2581	Mounting Bracket	B31189

Cpl 07.05.24

Seq. #:	Machine Or Operation:	Description :
6.0	D34421	Shim

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D3442-1	Shim	B30564

Cpl 07.05.24

Seq. #:	Machine Or Operation:	Description :
7.0	M304EX07516F	Expanded Metal Flat Stai

Comment: Qty.: 41.6745 sf(s)/Unit Total : 41.6745 sf(s)
Pick:

Qty	Part Number	Description	Batch
39.69 sf	M304EX0.75-16F	Expanded Metal	M103645

Cpl 07.05.24

Seq. #:	Machine Or Operation:	Description :
8.0	M304TS0750W065	304 SQ Tube.75x.75x.065W

Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)
Pick:
28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing
Batch: M104307

Cpl 07.05.24

Seq. #:	Machine Or Operation:	Description :
9.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

Cpl 07.05.24

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes (No) **DQA:** [illegible] **Date:** 07/05/25

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 3:09:55 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 30858A
Part Number: D2221

Job Number:

Seq. #:	Machine Or Operation:	Description :
10.0	QC9	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION		AA 07/05/24
11.0	QC6	DIMENSIONAL CHECK
Comment: DIMENSIONAL CHECK		AA 07/05/24
12.0	POWDER COATING	POWDER COATING
	M103141	
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		MJ 07-05-24 (1)
13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		mf 07-05-25 (1)
14.0	QC21	FINAL INSPECTION/W/O RELEASE
		(1)
Comment: FINAL INSPECTION/W/O RELEASE		07/05/25

Job Completion

U 07.05.25

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ PAR #: _______ Fault Category: ________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
BW	PH	
CHECKED	APPROVED	DRAWING NO. D2221 — REV. F — SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350) — SCALE NTS

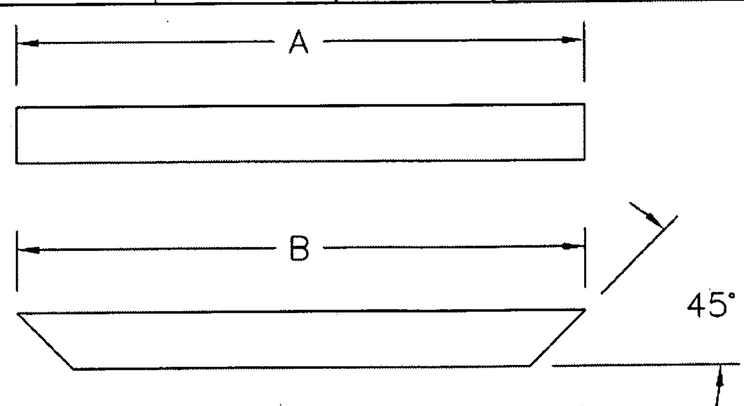
DART

RELEASED 05.08.19

REV	DATE	DESCRIPTION
C	95.11.21	SEPARATE BASKET AND LID
D	96.06.21	CHANGE LATCH
E	01.04.19	CHANGE HINGE
F	05.06.07	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS

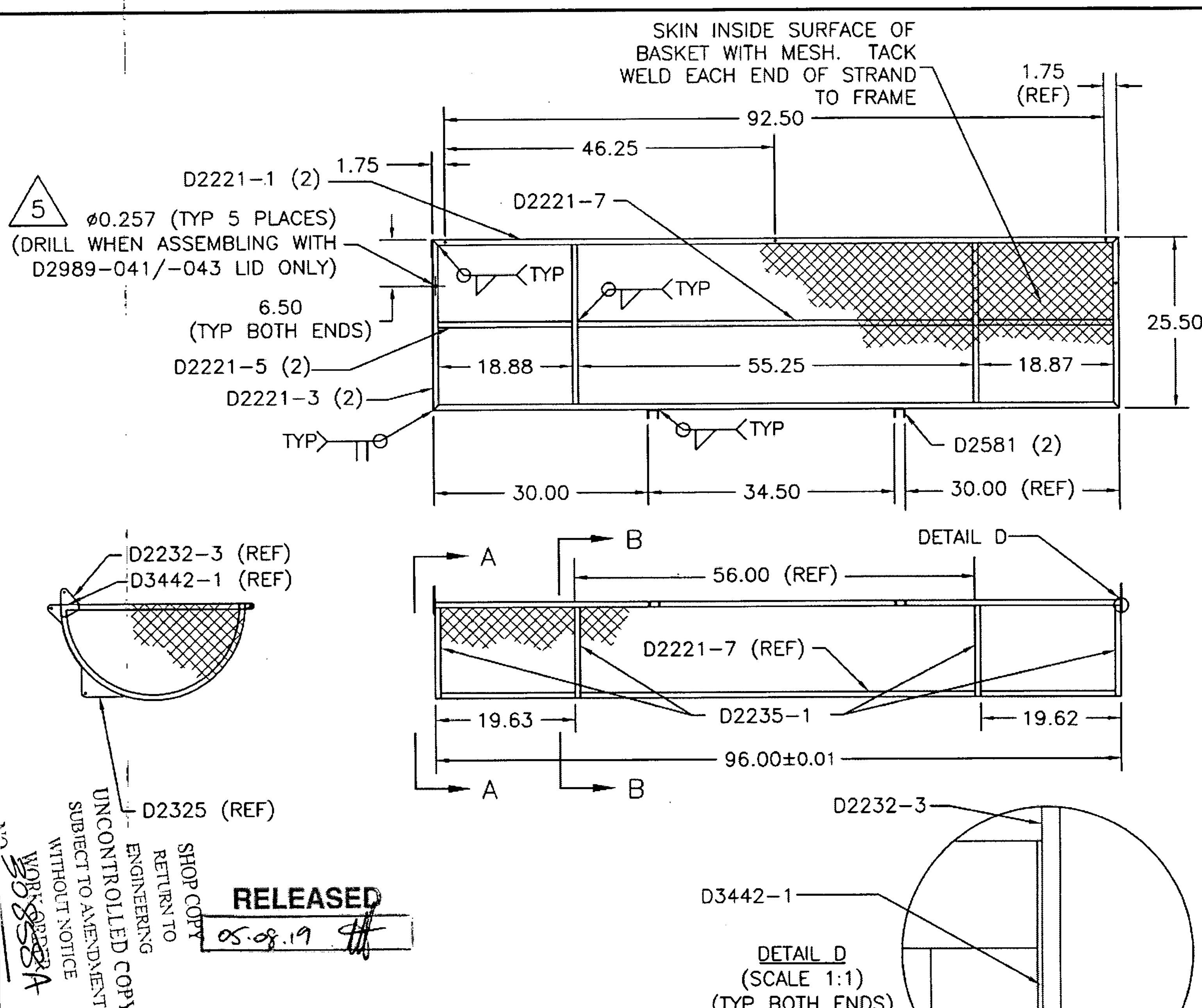
PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	——	96.00	RIB
D2221-3	2	——	25.50	RIB
D2221-5	2	18.88	——	RIB
D2221-7	1	55.25	——	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM



D2221-1/-3/-5/-7

1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING (REF. DART SPEC M304TS0.750W.060)
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) DRILL Ø0.257 HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH D2989-041/-043 BASKET LID



D2221 BASKET BASE ASSEMBLY

1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
2) WELD PER DART QSI 004
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

DART

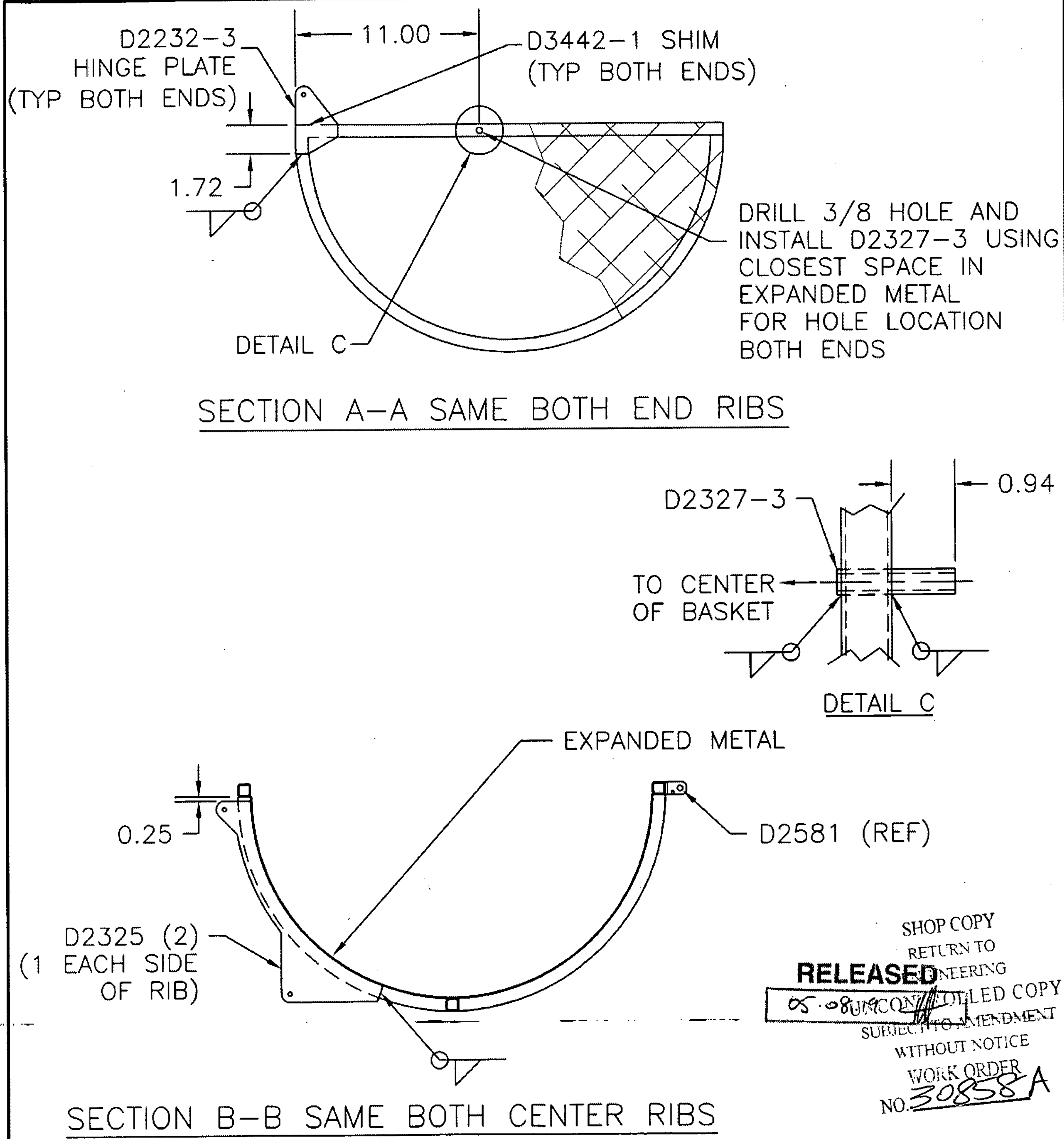
DESIGN	DRAWN BY
BW	PH
CHECKED	APPROVED
DATE 05.06.07	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2221
TITLE BASKET BASE ASSEMBLY (350)
REV. F
SHEET 2 OF 3
SCALE 1:20

DART

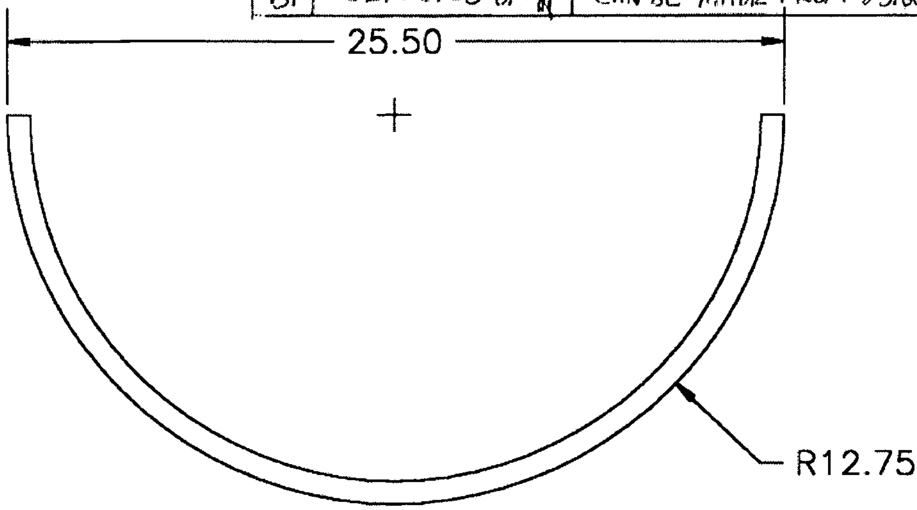
DESIGN BW	DRAWN BY PH	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2221	REV. F SHEET 3 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE 1:8



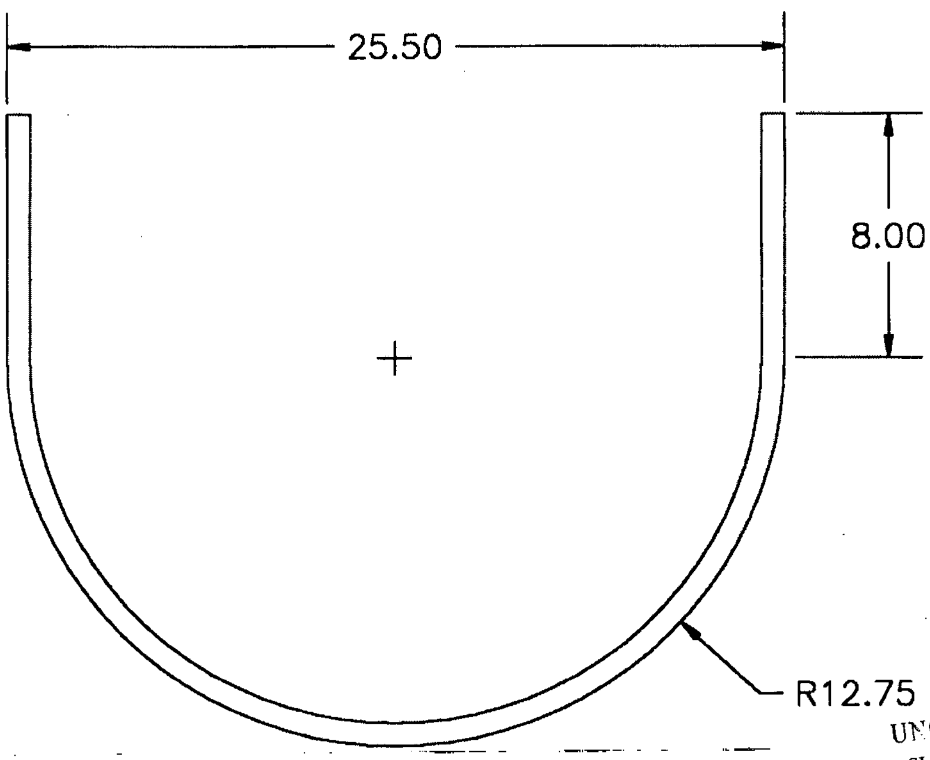
DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
B WILLIAMS	B WILLIAMS	
CHECKED	APPROVED	DRAWING NO. D2235 — REV. B — SHEET 1 OF 1
DATE 94:12:16		TITLE BASKET RIBS — SCALE
B1	02.08.06	CAN BE MADE FROM D3166-1

DART

RELEASED 960507



D2235-1



D2235-3

CAN BE MADE FROM D3166-1 B1

MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.